

5/13

SPLIT

DART AEROSPACE LTD	Work Order:	225246
Description: STA 84 bracket	Part Number:	D2803-2
Dwg: D2803 rev A	Qty:	20 12

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	JF	05.02.23	20 12
2	METAL	Cut blanks per template DT 8533 Material: 6061-T6 bar 10.00" x 0.50" Batch: M16933 M10627	J	05.03.14	30 12
3	HAAS	Machine as per folio FA102	SD	05.03.14	26 12
4	QC	Inspect Level 2	SD	05.03.14	12
5	QC	Inspect Level 8	EP	05/03/23	12
6	METAL	Tumble & Deburr	PK	05/03/23	12
7	QC	Inspect Level 5	EP	05/03/23	12
8	FINISHING	Chemical conversion coat per QSI 005	JG	05/03/28	12
9	STORES	Identify and stock	SB	05/03/28	12
10	EXPEDITING	Close W/O Cost / part: 65.48 \$ 40 05/03/29 12	JF	05.06.08	12

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	QA

RELEASED

EC 00.11.06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/03/15	# 3	one part scrap. extra mat. Debilitated the cutter	B per Q9142	destroy & replace	B - 05/03/15	B 05/03/15	B per Q9142	B 05/03/15
05-03-15	3	8 ^{3/4} pieces affected ocket milled at .240" instead of .250" which makes it .005" out of tolerance		for these 8 ^{3/4} parts only with face stop 0.000"				B 05-03-15

Part No: D2803-2

PAR #: _____

Fault Category: Prod / machine Parts

NCR:

Yes

No

DQA: DQA:

Date: 05/06/15

NOTE: Date & initial all entries

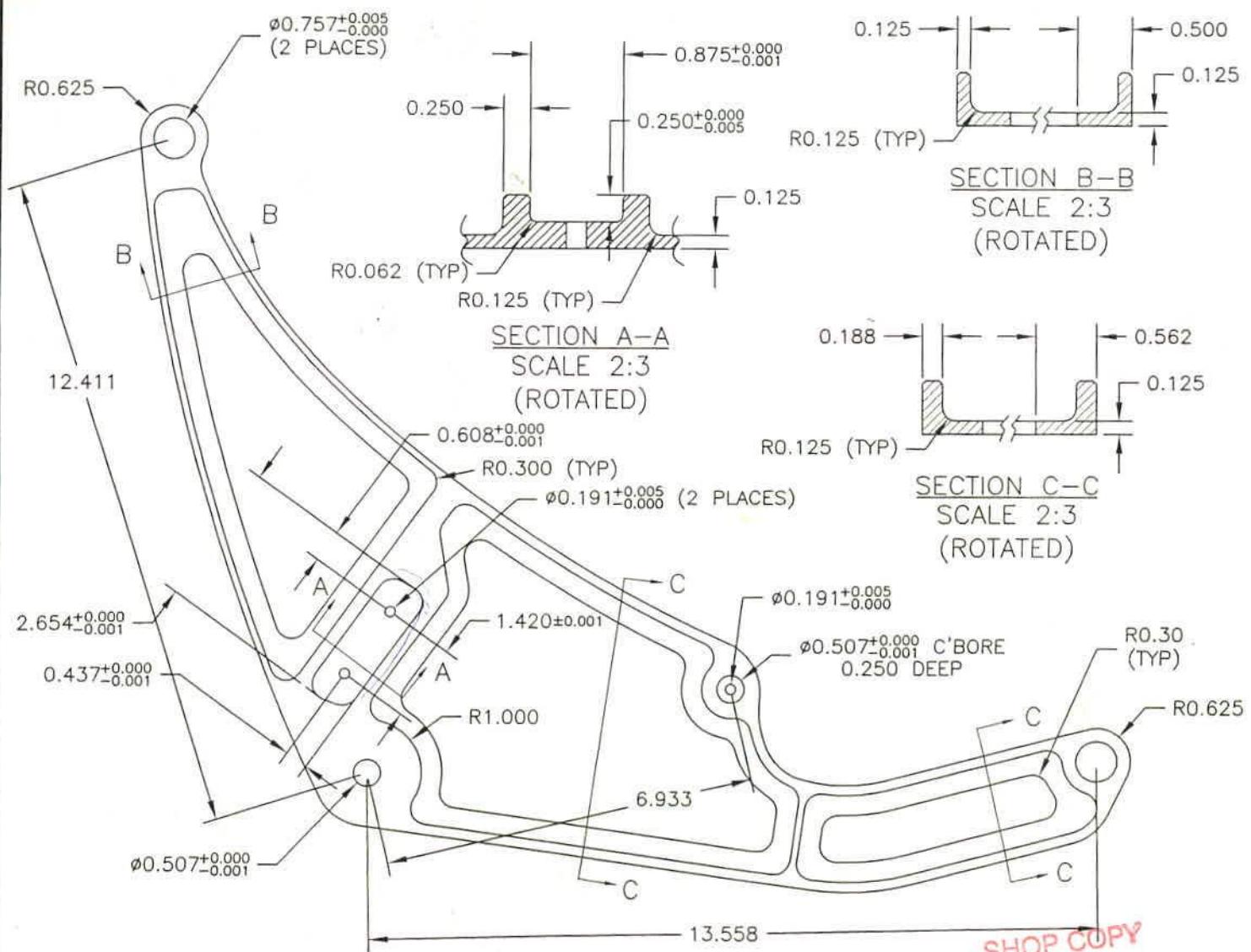
QA: N/C Closed:

Date: 05/06/15

PRELIMINARY ISSUE

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
	A	00.11.07	NEW ISSUE

B	04.11.22	ADD CUTOUTS & -043/-044
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SHOP COPY

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ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
NOTICE

WORK ORDER

NO. 22524

D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Job Costing Report

Dart Aerospace Ltd.
HawkesburyFeb 22, 2005
03:39 pm

Work Order No : 0022524
 Project Name : D2803-2
 Project For : WK513
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2803-2
 Description : STA 84 Bracket
 Manufactured : Yes
 Amount Req'd : 20
 Amount Done : 0
 Start Date : 02-22-05
 Est Finish Date : 03-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00	0.00	0.00
Total Cost :	0.00	0.00	0.00	0.00	0.00
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss)	0.00	0.00

DART AEROSPACE LTD

Work Order: 22524

Description:

Part Number: D2803-2

Inspection Dwg:

Rev:

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FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.757	+.005 -.000	.757	✓			Vern
1.720	+.001 -.001	1.719	✓			
Ø.191 x 3	.191	.191	✓			
.507		.507	✓			
Ø.507 x .250		.507 x .251	✓			
12.411		12.410	✓			TAPE
13.558		13.560	✓			TAPE
6.933		6.930	✓			TAPE
.250		.253	✓			Vern
.875	+.000 -.005	.874	✓)
.250		.253	✓			
.125		.129	✓			
.125		.127	✓			
.500		.501	✓			
.125		.128	✓			
.188		.189	✓			
.562		.565	✓			
.125		.131	✓			

Measured by:

SD

Date:

05.03.14

Audited by:

ML

Prototype Approval:

N/A

Date:

05/03/14

Date:

Rev

Date

Change

New Issue

Revised by

KJ/JLM

Approved